

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028026**Date Inspected:** 21-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Magnetic Particle Testing (OBG Lift 13W/14W)

This QA Inspector performed Magnetic Particle Testing (MT) of 100% of the HPS-485 longitudinal deck stiffener weld splices designated as LS13W/14W LS 1, LS13W/14W LS 2, LS13W/14W LS 3, LS13W/14W LS 4N and LS13W/14W LS 5N. This weld was previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

The QA inspector observed ABF/JV welding personnel performing grinding of the lifting lug assembly in order to remove the remaining cropped assembly from the longitudinal diaphragm previously utilized to lift the OBG to the temporary structure. The lifting lugs were removed to facilitate the fit up of additional stiffeners to the longitudinal diaphragm at a later date as seen in the attached photograph.

Ultrasonic Testing (OBG Deck Drop-in stiffener splices Lift 13 West)

This QA performed 100% Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) HPS-485 longitudinal deck stiffener weld splices. The welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in

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compliance with the contract specifications. The weld designations are as follows.

LS13W/14W LS 1

LS13W/14W LS 4N

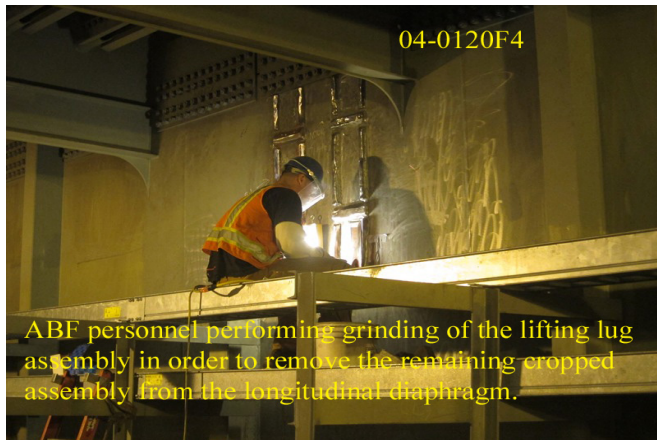
LS13W/14W LS 5N

This QA spent a portion of this reviewing and documenting the status and completion of various production welding tracking logs for lift 13E/14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
